

Date: Tuesday, 6/26/2007 3:31:23 PM
User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|--|--|------------------|-----------------------------|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : NO STEP LABEL | | |
| Job Number | : 33184 | | | | | |
| Estimate Number | : 10160 | | | | | |
| P.O. Number | : N/A | | Part Number | : D2137 | | |
| This Issue | : 6/26/2007 S.O. No. : N/A | | Drawing Number | : D2137 REV 93.29.06 | | |
| Prsht Rev. | : NC | | Project Number | : N/A | | |
| First Issue | : N/A | | Drawing Revision | : 93.29.06 | | |
| Previous Run | : 32198 | | Material | : N/A | | |
| Written By | | | Due Date | : 7/6/2007 Qty: 20 Um: Each | | |
| Checked & Approved By | | | | | | |
| Comment | : Est: B 02.02.01 Added step 3 and Inspection level 21 SM | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|--|--------------------------|
| 1.0 | PG | PURCHASING | |
| | | Comment: PURCHASING Issue P/O <u>4060</u> <i>(26/10/28)</i> (20) | |
| | | Make per Dwg 2137 | |
| 2.0 | D2137P | Decal - No Step | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) DECAL- NO STEP | |
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 | |
| | | Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached | <i>(27/7/6) (21)</i> |
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP | <i>(27/7/6) (21)</i> |
| | | Comment: INSPECT WORK TO CURRENT STEP | <i>(27/7/6) (21)</i> |
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 | <i>(27/7/6) (21)</i> |
| | | Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST16 | <i>(27/7/6) (21)</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/09
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Process Sheet

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|---|-----------------------|------------------------------|
| Customer: CU-DAR001 Dart Helicopters Services | | Drawing Name: NO STEP LABEL |
| Job Number: 33184 | | Part Number: D2137 |
| Job Number: | | |
| Seq. #: | Machine Or Operation: | Description : |
| 6.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
| | | (21) D07/07/09 |
| Comment: FINAL INSPECTION/W/O RELEASE | D07/07/09 | |
| Job Completion | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

NATURAL (SILVER) - 003 THICK
WHITE) ON BLACK.

MATERIAL: 3M ROLTESTER

50-50-00 ✓
50-60-00 //

522cp

ENCL.
UNCONTROLLED COPY
AMENDMENT
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER



Scotchcal™ Opaque Imaging Media 8522

Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
 - For opaque (reflective) graphics
 - Changeable, easy to remove from warranted substrates up to 1 year later
 - Dries quickly after printing so the overlaminates can be applied almost immediately
 - Low slippage paper liner for superior tiling
- Overlaminate:
 - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
 - Available in luster and matte gloss
 - Adhesive allows for heat-assisted or cold-temperature lamination

Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
 - Graphics for vans, personal vehicles, trucks and buses
 - Novelty posters
 - Retail and point-of-purchase displays
 - Information graphics such as maps and directories
 - Entertainment promotions in museums, zoos, parks, theatres, sports venues
 - Education and presentation graphics

- Legal and courtroom exhibits

- For flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications

Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wallboard
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

Compatible Products and Equipment

Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
 - Epson Archival Inks
- Epson Stylus Pro 10600 printer
 - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
 - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
 - HP83UV Color Ink System

Overlaminate (required)

- 3M™ Luster Overlaminate 8519 (semi-gloss)
- 3M™ Matte Overlaminate 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

Shelf Life and Storage

- 3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 has a shelf life of one year.
- Storage conditions (new and partially used rolls). For optimum performance, use the middle of these ranges:
 - Original packaging, including plastic wrap
 - Relative humidity of 20% to 80%
 - Temperature of 33° to 104°F (0° to 40°C)
 - Away from direct sunlight
- Do not stack unprotected rolls or lay sharp or heavy objects on them.

Health and Safety



Caution

When handling any chemical products, read the manufacturers' container labels and the Material Safety Data Sheets (MSDS) for important health, safety and environmental information.

To obtain MSDS sheets for 3M products:

- By fax, call 1-800-364-0768 in the US and Canada or 1-650-556-8417 for all other locations.
- Electronically, visit us at <http://www.3M.com/msds>.
- By mail, or in case of an emergency, call 1-800-364-3577 or 1-651-737-6501.

When using any equipment, always follow the manufacturers' instructions for safe operation.

Warranty and Limited Remedies

3M™ MCS™ Warranty for Graphics Produced on HP DesignJet Printers and Epson Stylus Pro Printers

The following is made in lieu of all other express or implied warranties, including any implied warranty of merchantability or fitness for a particular purpose: We warrant graphics produced by a 3M Ink Jet Registered Fabricator made with imaging media 8522, printed on an approved HP thermal ink jet printer according to HP's recommendations or Epson Stylus Pro printer according to Epson's recommendations, overlaminated with 8519 or 8520, and applied to a Waranted Substrate according to 3M's recommendations. These



Commercial Graphics Division

3M Center, Building 220-6W-06
PO Box 33220
St. Paul, MN 55133-3220 USA
General Info. 1-800-374-6772
Technical Info. 1-800-328-3908
Fax 1-651-736-4233

Fax-on-Demand 1-800-364-0768 US/Canada or 1-651-732-6506 International
Fax-on-Demand document: 4506
www.scotchprint.com

3M Canada

P.O. Box 5757
London, Ontario
Canada N6A 4T1
1-800-265-1840
Fax 519-452-6245

3M México, S.A. de C.V.

Av. Santa Fe No. 55
Col. Santa Fe, Del. Alvaro Obregón
México, D.F. 01210
52-55-52-70-04-00
Fax 52-55-52-70-22-77

3M Puerto Rico, Inc.

Puerto Rico Industrial Park
P.O. Box 100
Carolina, PR 00986-0100
787-620-3000
Fax 787-750-3035

graphics are covered against failure caused by ultraviolet light, temperature extremes, pollution, and other elements.

If a graphic fails to perform in accordance with 3M product specifications within this time frame, 3M will replace the materials at no charge. **These remedies are exclusive. In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor charges.**

3M Related Literature

Listed below is related 3M technical literature that may be of interest. You may view and print these Bulletins from our Web site at www.scotchprint.com, or order them via our Fax-on-Demand (FOD) system. Call one of these phone numbers to order the desired bulletins, and specify the FOD document number provided in the chart.

United States or Canada: 1-800-364-0768

International: 1-651-732-6506

| Subject | Bulletin No. | FOD No. |
|---|--------------|---------|
| Product Bulletins | | |
| 3M™ Scotchcal™ Overlaminate 8519 and 8520 | 8519/8520 | 4524 |
| Instruction Bulletins | | |
| Making thermal ink jet graphics | 4.23 | 6523 |
| Application, substrate selection, preparation and substrate-specific application techniques | 5.1 | 7001 |
| Warranties | | |
| Worldwide 3M™ MCS™ Warranty Packet (includes all Commercial Graphics MCS Warranties) | | 9503 |
| Worldwide 3M™ MCS™ Warranty Overview-Folder | | 9504 |

3M, Scotchcal and MCS are trademarks of 3M.

Epson and Stylus Pro are trademarks of Epson.

HP and DesignJet are tradenames of Hewlett Packard.

Sintra is a trademark of Swiss Aluminum Ltd.

Imron is a registered trademark of DuPont in the United States

Bulletin Change Summary

The Epson Stylus Pro Printers 9500, 10000 10600, and Epson Archival Inks have been added to this bulletin. Additional changes resulting from this addition are marked with black bars in the margin.